Work Order ID 85586

Monday, June 11, 2012 1:48:16 PM

85586

Item ID: D2649
Revision ID:
Item Name: Cross Bolt Spacer

Accept *N900040100*

Setup Start *NS1*
Stop *NS2*

Start Date: 6/11/2012 **Start Qty:** 200.00 *200*
Required Date: 6/13/2012 **Req'd Qty:** 200.00 *200*
Reference:

Cust Item ID:
Customer:

Approvals: **Process Plan:** WF **Date:** 12-06-11 **Tooling:** ______ **Date:** ______
QC: ______ **Date:** ______ **SPC (Y/N):** ______ **Date:** ______

Run Start *NR1*
Stop *NR2*

Draw Nbr	Revision Nbr
D2649	Rev B1

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
100 *100* Hardinge Hardinge CNC Lathe Small	Hardinge CNC LATHE SMALL **Memo** Machine as per folio FA214 on cobra machine.	0.00 0.00	12/06/28			208	∅		
110 *110* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB **Memo**	0.00 0.00	12/06/28			208	∅		
120 *120* QC Quality Control	QC8- Inspect parts - second check **Memo**	0.00 0.00	12/6/28			208	∅		

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Item ID: D2649 **Accept** *N900040100* **Setup** **Start** *NS1*

Revision ID:

Item Name: Cross Bolt Spacer **Stop** *NS2*

Start Date: 6/11/2012 **Start Qty:** 200.00 *200* **Cust Item ID:**

Required Date: 6/13/2012 **Req'd Qty:** 200.00 *200* **Customer:**

Reference:

Approvals: **Process Plan:** ______ **Date:** ______ **Tooling:** ______ **Date:** ______ **Run** **Start** *NR1*

QC: ______ **Date:** ______ **SPC (Y/N):** ______ **Date:** ______ **Stop** *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
125 *125* Skidtubes Skidtubes	Memo 1- clean crossbolt spacer with ultra brigth aluminum cleaner before storing.	0.00 0.00				208	0		BE 12/07/03
130 *130* Packaging Packaging	Identify as per dwg & Stock Location: LG Memo ***STOCK IN SKIDTUBE CELL***	0.00 0.00				208	0		BE 12/07/03
140 *140* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00						12/7/4	[illegible]

MF 12-07-04

Picklist Print

Monday, June 11, 2012 1:48:15 PM

Work Order ID: 85586

Parent Item: D2649

Parent Item Name: Cross Bolt Spacer

Start Date: 6/11/2012 **Required Date:** 6/13/2012

Start Qty: 200.00 **Required Qty:** 200.00

Comments: IPP F02.03.26Added turning on CobraNG IPP Rev:G 10.05.11 added cleaning DD verified :EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6T0.375W.058 6061-T6 RD Tube .375 x.058W		Purchased	No			100	f	397.0360	**0.2833**	**59.642105** 60.000'		12/06/28	

Location		Loc Qty	Loc Code	
MAT014		397.036		
	116920	0.578		
	119087	8.56		
	→ 119376	270		60.000'
	119678	66		
	120633	51.898		

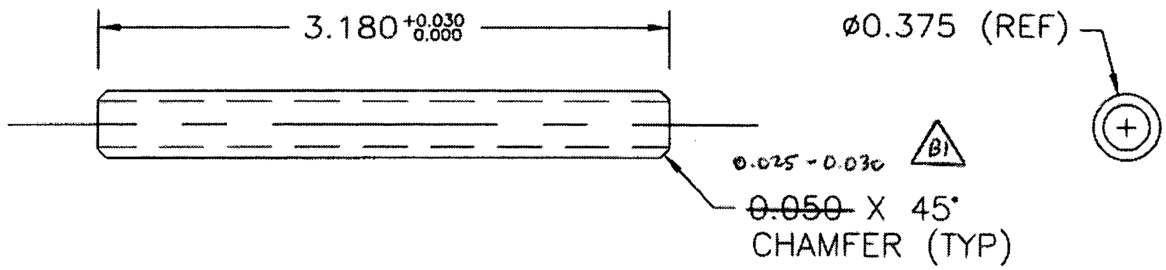
DART (QA COPY ISSUED)

DESIGN	DRAWN BY	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED	APPROVED	DRAWING NO. D2649	REV. B SHEET 1 OF 1
DATE 98.01.14		TITLE CROSS BOLT SPACER	SCALE 1:1

REV	DATE	DESCRIPTION
A	97.03.25	NEW ISSUE
B	98.01.14	3.180 WAS 3.230, ADD CHAMFER
B1	02.06.13	REDUCE CHAMFER PER TSR 1296.

RELEASED 98.01.20 DS

2R558 #



MATERIAL: 6061–T6 (WW–T–700/6) OR 5052–H32 (WW–T–700/4)
0.375 DIA 0.058 WALL
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DART AEROSPACE LTD	Work Order:	85586
Description: Crossbolt Spacer	**Part Number:**	**D2649**
Inspection Dwg: D2649 **Rev:** B1		**Page 1 of 1**

FIRST ARTICLE INSPECTION CHECKLIST

[X] **First Article** [ ] **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.180	+0.030/-0.000	3.195	✓		S208	Vern
0.375	+/-0.010	.375	✓		↓	
0.025 – 0.030	N/A	.027	✓		↓	

Measured by:	[signature]
Date:	12/06/28

Audited by:	[signature]
Date:	12/6/28

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.01.21	New Issue	KJ/RF [signature]	[signature]